









Work Order ID 61581

Monday, August 30, 2010 12:44:44 PM




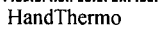
Page 1

Item ID: D3946-1 Accept  Setup Start 
Revision ID:
Item Name: Panel, Center Post 3:00  Stop 
Start Date: 8/30/2010 Start Qty: 1.00-
Required Date: 9/6/2010 Req'd Qty: 1.00  Cust Item ID:
Customer:
Reference:

Approvals: Process Plan:  Date: 10-8-30 Tooling: Date:
QC: Date: SPC (Y/N): Date:
Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3946	A								

100  HAND FINISHING THERMOFORMING 0.00
HandThermo  Memo 0.00
Hand Finishing Thermoforming Cut Blanks to fit frame size

105  Dry Material 0.00
HandThermo  Memo 0.00
Hand Finishing Thermoforming Dry Sheet as per OS1022 POLYCARBONATE
Temp: 210
Time IN: 4:30 10/10/05
Time OUT: 7:00 10/10/06

(x3)

BB 10/10/05

BB 10/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61581

Monday, August 30, 2010 12:44:44 PM

Page 2

Item ID: D3946-1

Accept

Revision ID:

Item Name: Panel, Center Post

Start Date: 8/30/2010 Start Qty: 1.00

Required Date: 9/6/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	THERMOFORMING MACHINE	0.00							
	Thermoform	0.00							
	Thermoforming Machine								
	Memo								
	1-Machine Set-up								
	2-Pre-heat tool								
	3-Thermoform as per Dwg. D3646-1 and Folio FTA 043 using tool DT9483								
	Dwg. Rev. _____								
	Folio Rev. _____								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
	Quality Control								
	Memo								
	Visually inspect for proper formation of each part								
130	QC8- Inspect parts - second check	0.00							
	QC	0.00							
	Quality Control								
	Memo								

BB 10/10/06

BB 10/10/06

BB 10/10/06

X3

X3

BB 10/10/06

BB 10/10/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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[illegible]

Page 3

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves assigning tasks to team members, setting deadlines, and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

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84

Cust Item ID:

Page 10 of 10

Customer:

[REDACTED]



**Insp.
Stamp**

140


0.00

Memo

0.00

Trim to Finished Dimensions as per dwg D3946-1

150


0.00

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

160

0.00

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61581

Monday, August 30, 2010 12:44:44 PM



Page 4

Item ID: D3946-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Center Post

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 150

0.00

Packaging

Memo

0.00

Packaging

10/10/06 32

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/06 32
mr
10-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 12:44:49 PM

Page 1

Work Order ID: 61581

Parent Item: D3946-1

Parent Item Name: Panel, Center Post



Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,865.801	3.305	3.478947			
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

therm

1865.801

107574

6.46

111973

27.395

112176

101.2267

114459

1730.7193

X3

10/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61581
Description: Panel, Center Post		Part Number: D3946-1
Inspection Dwg: D3946	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL

Date: 10/10/06

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.25	REF	39.25"	✓			
1.25	REF	1.25"	✓			
3.2	REF	3.22"	✓			
0.070	Min	0.072"	✓			

Measured by: DL

Date: 10/10/06

Audited by: BB

Date: 10/10/06

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>[Signature]</u>

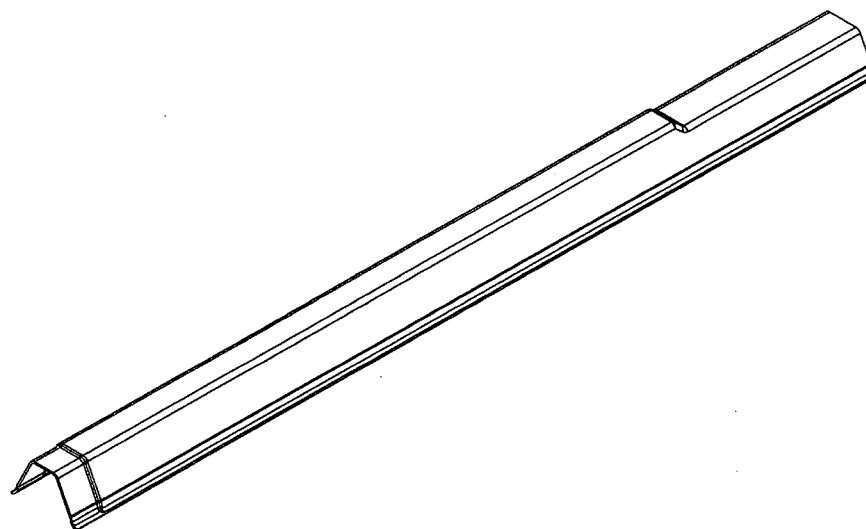
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NOTE: Date & initial all entries



D3946-1 PANEL, CENTER POST

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 61581
BS10-8-30

RELEASED
9/26/14

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
 REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3946-1" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.070" UNLESS OTHERWISE NOTED

A		NEW ISSUE		PH	09.05.19
REV.		DESCRIPTION		BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	PH				
CHECKED	92	DRAWING NO.		REV. A	
MFG. APPR.	92	D3946		SHEET 1 OF 2	
APPROVED	92	TITLE		SCALE	
DE APPR.	92	PANEL, CENTER POST		NTS	
DATE	09.05.19	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

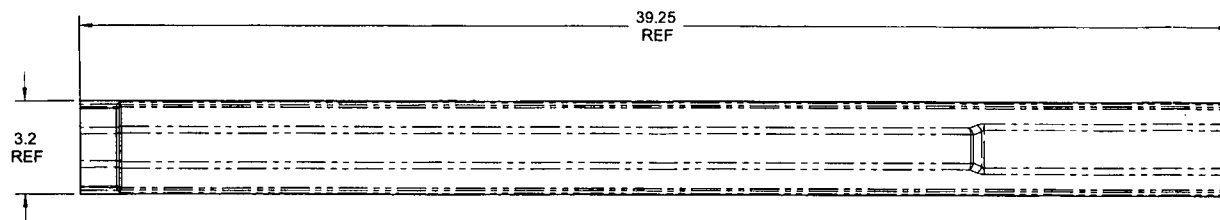
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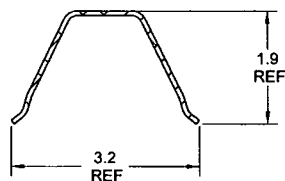
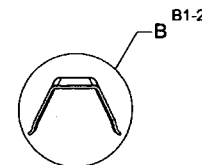
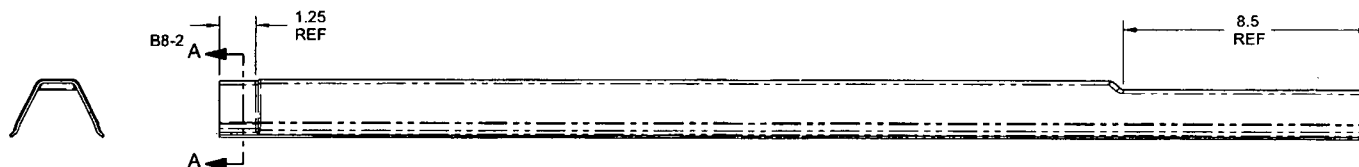
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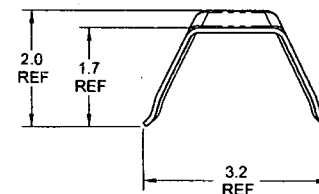


RELEASED
9/6/81



SECTION A-A C7-2
SCALE 2X

D3946-1 PANEL, CENTER POST



DETAIL B C1-2
SCALE 2X

w/c 41581

DESIGN	42	DART AEROSPACE LTD	
DRAWN	PG	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PG	DRAWING NO.	REV. A
MFG. APPR.	PG	D3946	SHEET 2 OF 2
APPROVED	PG	TITLE	SCALE
DE APPR.	PG	PANEL, CENTER POST	NTS
DATE	09.05.19	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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